

Date: Tuesday, 9/4/2007 11:29:52 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: EYEBALL ADAPTER
Job Number	: 34404		
Estimate Number	: 12237		
P.O. Number	: <i>N/A</i>	Part Number	: D34803
This Issue	: 9/4/2007 S.O. No. <i>N/A</i>	Drawing Number	: D3480 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 32043	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 10/4/2007 Qty: 6 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: est rev. A 06.02.07 new issue EC Est. Rev B Now on Water jet 06.04.18 EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S26GA	304/316 0.018 SHEET
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Comment: Qty.: 0.0662 sf(s)/Unit Total : 0.3969 sf(s)  
 AISI 304/316 0.018 SHEET Batch: *M 105 440 IB 07-09-06*

2.0	WATER JET	FLOW WATER JET
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*PROG B  
DWG B*

*IB 07-09-06*



*(6)*

Comment: FLOW WATER JET  
 Cut as per dwg D3480

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



*IB 07-09-06*



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

*En 07/09/06 (46) counter*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
 1-Roll as per dwg D3480  
 2-Spot weld as per dwg D3480  
 3-Deburr

*SMD 07/09/06 (6)*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 7/10/17  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/4/2007 11:29:52 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EYEBALL ADAPTER

Job Number: 34404

Part Number: D34803

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

~~QC~~ QC11

VISUAL WELDING INSPECTION

GA



Comment: VISUAL WELDING INSPECTION

SB 07/09/10

6

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/09/10

6

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 07/09/10

6

9.0

QC21

FINAL INSPECTION/W/O RELEASE



6

Comment: FINAL INSPECTION/W/O RELEASE

DO 10/09/11

Job Completion



u 07/09/11

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

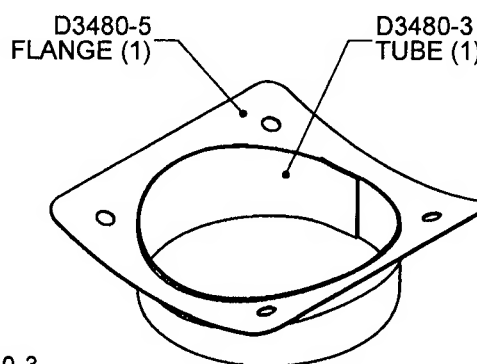
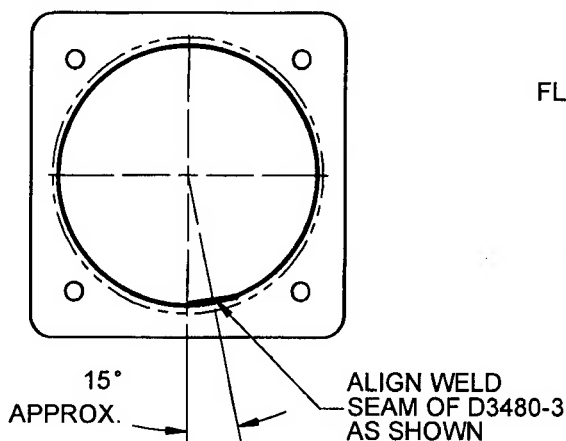
**NOTE:** Date & initial all entries



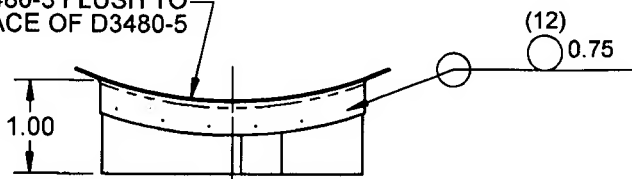


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CHECKED <i>PH</i>	APPROVED <i>H</i>	DRAWING NO. <b>D3480</b>	REV. B SHEET 1 OF 6
DATE <b>06.08.29</b>		TITLE <b>EYEBALL ADAPTER</b>	SCALE 1:2
A	06.02.06	NEW ISSUE	
B	06.08.29	D3480-3 0.50 was 0.40/D3480-3F 8.930 was 9.330	



SPOT WELD PARTS, THEN  
CUT D3480-3 FLUSH TO  
SURFACE OF D3480-5



### D3480-041 EYEBALL INLET ADAPTER

#### NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3480-041	EYEBALL INLET ADAPTER
1	D3480-3	TUBE
1	D3480-5	FLANGE

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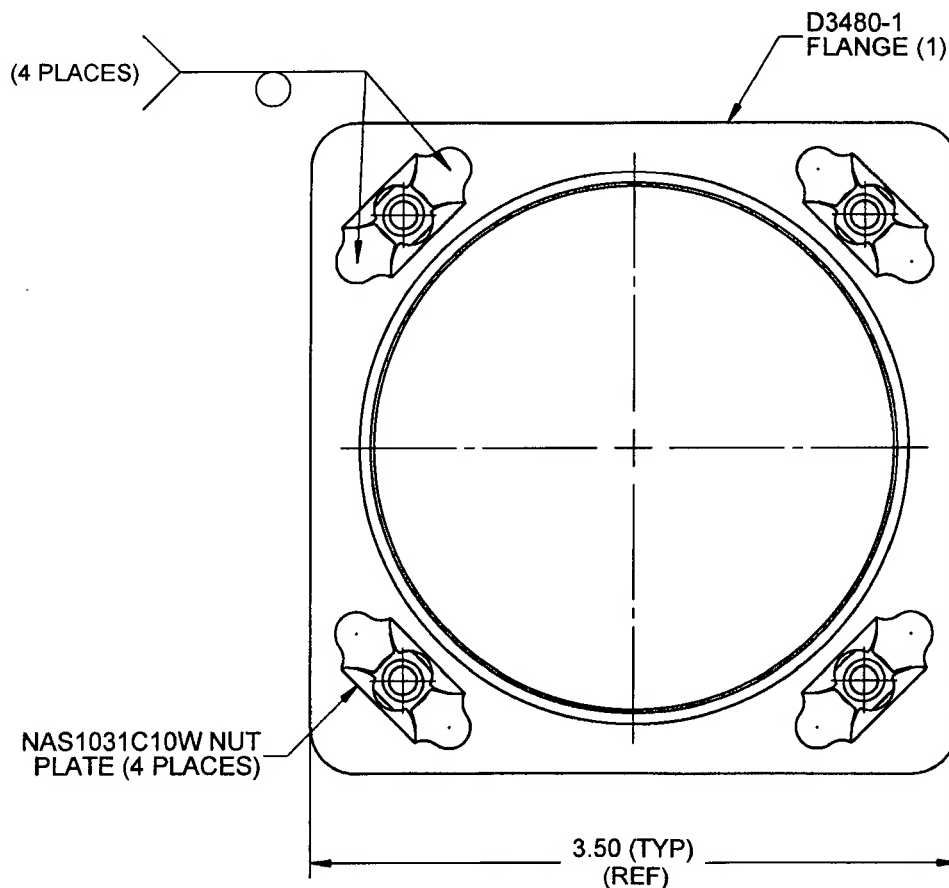
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DATE <b>06.08.29</b>		TITLE <b>EYEBALL ADAPTER</b> SCALE 1:1	

**RELEASED**06.09.19 *[Signature]***D3480-043 EYEBALL ADAPTER**

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**NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-043 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -043	P/N	DESCRIPTION
X	D3480-043	EYEBALL ADAPTER
1	D3480-1	FLANGE
4	NAS1031C3W	NUTPLATE

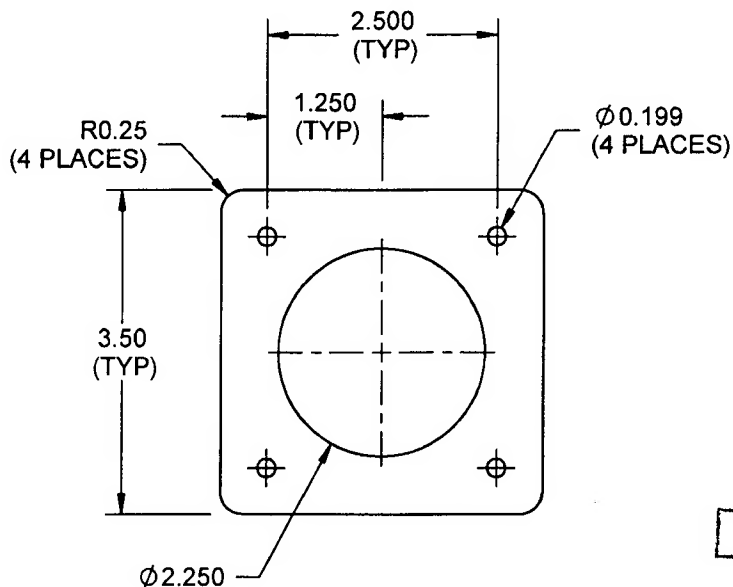
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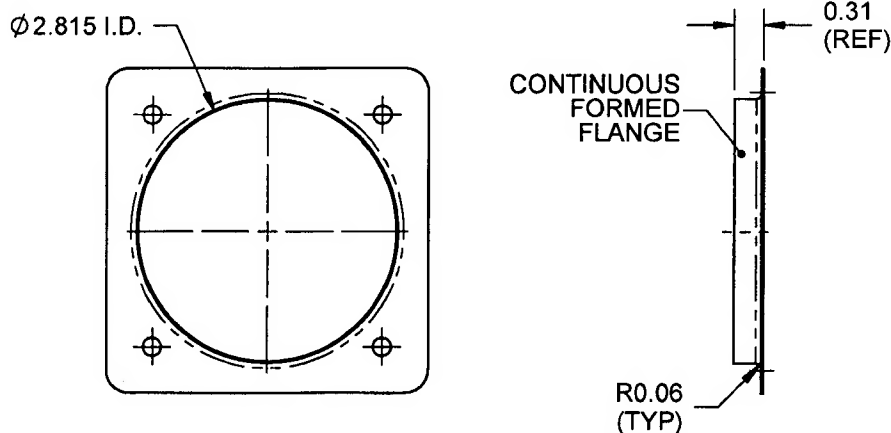


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DATE 06.08.29		TITLE EYEBALL ADAPTER	SCALE 1:2



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### D3480-1F FLAT PATTERN



### D3480-1 FLANGE (MAKE FROM D3480-1F)

#### NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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THE CHURCH

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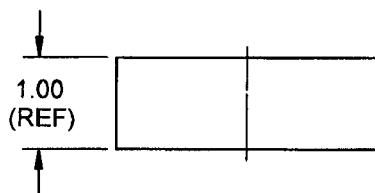
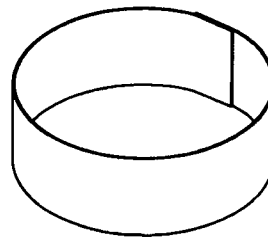
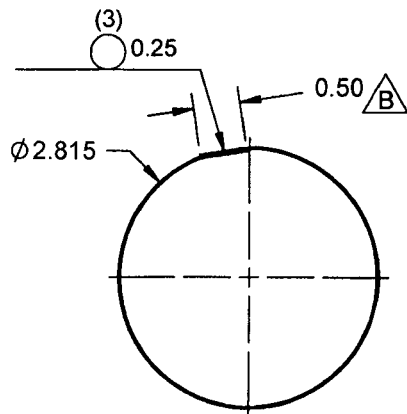
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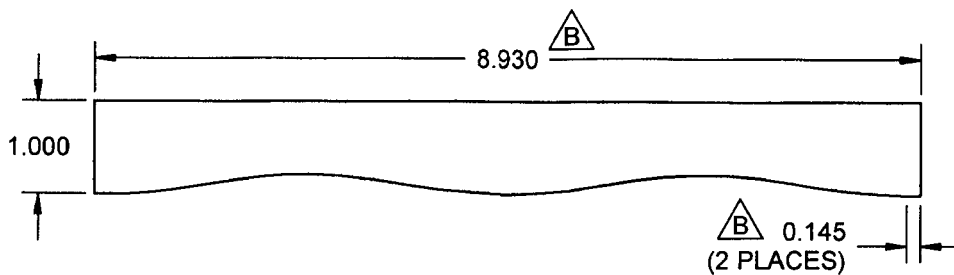
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DATE 06.08.29		TITLE EYEBALL ADAPTER	SCALE 1:2



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06.09.19 *AB*

### D3480-3 TUBE



### D3480-3F TUBE FLAT PATTERN

#### NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

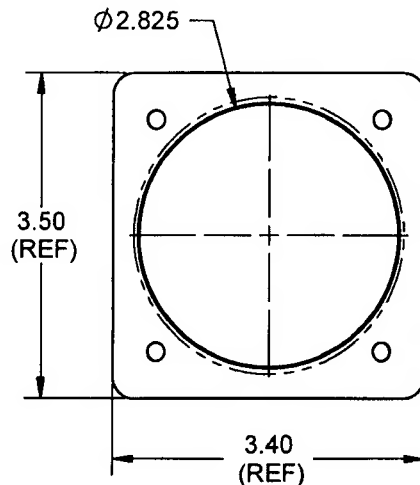
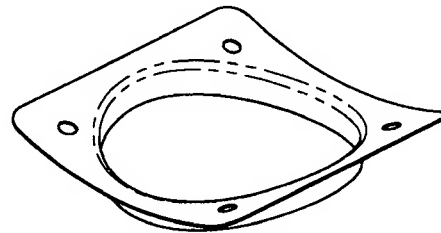
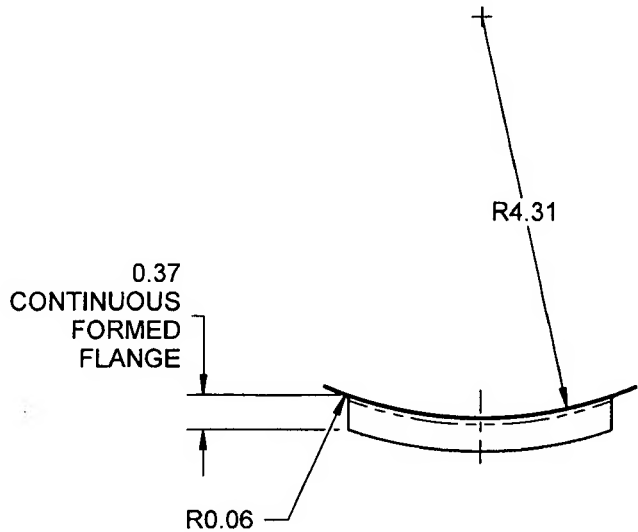
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DATE <b>06.08.29</b>		TITLE <b>EYEBALL ADAPTER</b>	SCALE 1:2

**RELEASED**06.09.19 *H***D3480-5 EYEBALL ADAPTER FLANGE****NOTES:**

- 1) MATERIAL: MAKE FROM D3480-1F
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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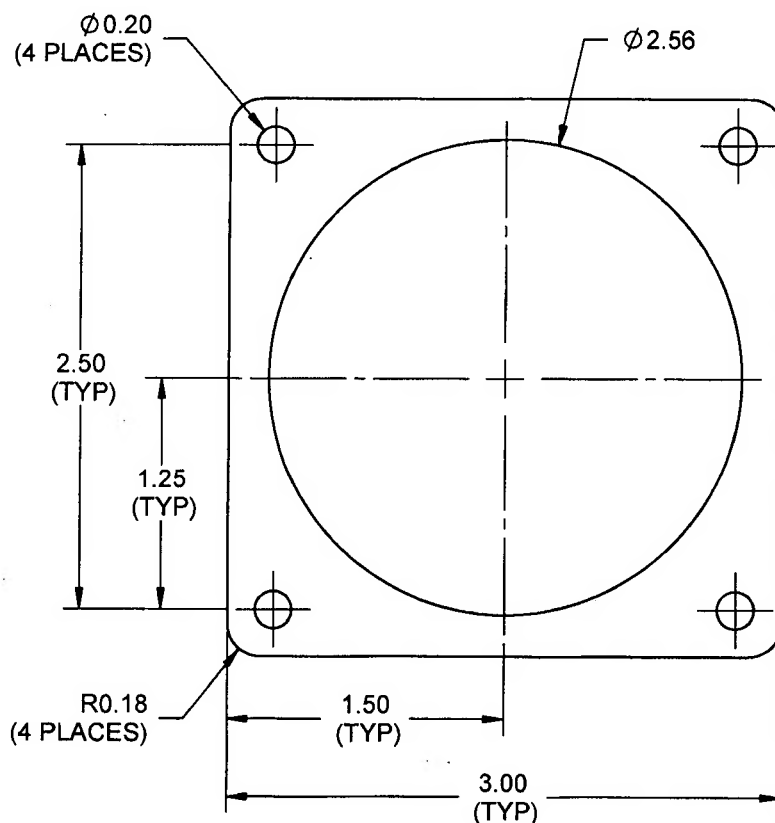
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DATE 06.08.29		TITLE EYEBALL ADAPTER	SCALE 1:1



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06.09.19 *[Signature]***D3480-7 GASKET****NOTES:**

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.125" THICK (REF. DART SPEC. M-SIL60-125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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**SPOT WELD TEST RECORD**  
**AMS-W-6858A**  
**CLASS 'C'**

**TEST NO#:** 9

**EMPLOYEE:** Manigum Lapage

**PART NUMBER:** D 3480-3

**JOB NUMBER:** B 34404

**MATERIAL TYPE:** 304L

**MATERIAL THICKNESS:** .018

**GROUP SPECIFICATION**

- ☐ Group 1: Aluminum & magnesium
- ☐ Group 2: Iron; nickel; cobalt
- ☒ Group 3: Titanium

**TEST RESULTS**

	PASS	FAIL
VISUAL:	<input checked="" type="checkbox"/>	<input type="checkbox"/>
PENETRATION:	<input checked="" type="checkbox"/>	<input type="checkbox"/>
PULL STRENGTH:	<input checked="" type="checkbox"/>	<input type="checkbox"/>

PSI Reading: \_\_\_\_\_

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

**DATE OF TEST COUPON:** 07/09/10  
**QUALIFIER:** QB